

Date: Tuesday, 1/24/2006 2:44:18 PM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : WEARPAD
<b>Job Number</b> : 25600	
<b>Estimate Number</b> : 11355	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D334015
<b>This Issue</b> : 1/24/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D3340 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : PURCHASED PARTS	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 25194	<b>Material</b> : N/A
<b>Written By</b> : <u>SEE COMMENT BELOW</u>	<b>Due Date</b> : 1/31/2006 <b>Qty:</b> 2 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>SEE COMMENT BELOW</u>	
<b>Comment</b> : Est: A 05.11.10 Preliminary issue AP/EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 2008674

Email of ship DXF file to vendor

Laser Cut per Dwg D3340 flat pattern D3340-15

Material release note required

u 09-19-05

2.0	D334015F	Wearplate
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)  
 Wearshoe

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure material release note is attached

0205/10/17 2

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Inspect dimensions

See Attached sheets

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Deburr if necessary

Form on brake as per Dwg D3340 using Jigs DT 8261 and DT 8326

SB 06/01/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 25600

Part Number: D334015

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



*Jan. 25*

2

Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*g.m 06-02-09*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*FC 06 02 10*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *57363*

*PU 6/2/10 (2)*

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*545 06/02/03 (2)*

*D 06/02/13*

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   *LD*   Date:   06/02/13  

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

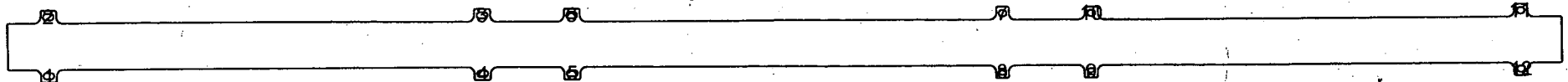
NOTE: Date & initial all entries

Drawing name..... D3340-15A1  
Revision.....  
Material number..... 0003, MILD STEEL, 20GA, .036  
Last modified date... 10-20-2005  
Programmed by..... jm

Comment.....  
Customer name... Dart  
Description.....  
Specification.....

m19184

Dim check: 13 05/12/02 (2)



Cutting distance = 147.0534  
Rapid distance = 113.4155

**REFERENCE ONLY**

2.815 x 61.3125  
1=5



New Zealand Steel Limited  
Glenbrook, South Auckland  
Postal: Private Bag 92121, Auckland, New Zealand  
Telephones: (09) 375 8889 / 375 8111 Auckland  
(08) 235 8069 / 235 3535 Waiuku  
Fax: (08) 375 8859

# TEST CERTIFICATE

Ref: 5005/21329

CUSTOMER	Wilkinson	P41007PI002	SPECIFICATION	ASTMA1008 CS Type A	CERTIFICATE No	TC107796																			
CUSTOMER O/N	90-21N-288		PRODUCT	CRA WIDE COIL	PAGE	1 of 1																			
MILL O/N	453665		DIMENSIONS	0.033" x 48" x Coil	DATE	31 March 2005																			
PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT														MECHANICAL TESTS (TEST SPECIFICATION - ASTMA370)									
		C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE ( )	BEND	YIELD	T.S.	%ELONG	HARDNESS	r	LENGTH	
		x100			x1000											x10000		x100		180°				G.L.=	HRB
R9-455932-00	640077	5	TR	20	10	16	14	17	18	1	6	1	1					Good				41		2621	
R9-455933-00	640077	5	TR	20	10	16	14	17	18	1	6	1	1					Good				41		2723	
R9-455934-00	640077	5	TR	20	10	16	14	17	18	1	6	1	1					Good				50		2546	
R9-455935-00	640077	5	TR	20	10	16	14	17	18	1	6	1	1					Good				50		2789	

YIELD	GAUGE LENGTH (G.L.)	PLASTIC STRAIN RATIO (r)	IMPACT TEST	(C)=5mm x 5mm	CARBON EQUIVALENT VALUE (CE)
(A)=0.2% PROOF STRESS	(A)=200mm (C)=80mm (E)=2"	(A)=r0 (C)=r45	(A)=10mm x 10mm	(D)=2.5mm x 10mm	(A)=C+Mn/6
(B)=LOWER YIELD STRESS	(B)=50mm (D)=5.65? So (F)=8"	(B)=r90 (D)=(r0+r90+2r45)/4	(B)=7.5mm x 10mm	(E)=5mm x 10mm	(B)=C+Mn/6+(Cr+V+Mo)/5+(Cu+Ni)/15
					(C)=C+Mn/6+Si/24
					(D)=

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED  
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED

*Atish Misra*  
QC METALLURGIST

20 GA CRMS

850711MD014-1 T M INDUSTRIAL (P41007DI002.640077)